

Work Order ID 64829

December 16, 2010 2:47:16 PM



Page 1

Item ID: D3253-1

Accept



Setup Start



Revision ID:

Rush

Stop



Item Name: Small Shelf

Start Date: 12/16/10 Start Qty: 2.00



Cust Item ID:

Required Date: 12/20/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

CL

Date: 10/12/16 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3253

Rev A

100

0.00



PURCHASING

0.00

Waterjet

Memo

FLOW CNC Waterjet

Program rev:

drawing rev:

B10-12-16

Q

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-12-16

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/17

(42)

130

small F>b

Band per drawing

(131 QCS) - 8/10/17

Sn 10/12/17

@

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=) M 10/12/17

2 0

160

Black Sandtex (Ref: 4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:20

OVEN TEMPERATURE:

FINISH TIME:

11:50

2 10-12-20

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=) M 10/12/20

2 4

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Page 3

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Item Name: Small Shelf

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Cust Item ID:

Required Date: 12/20/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Packaging Packaging	Identify as per dwg & Stock Location: <u>144</u> Memo	0.00 0.00				<u>10/2/00</u>		<u>22</u>	
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/12/20</u> <u>mf</u> <u>10-12-20</u>

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Picklist Print

December 16, 2010 2:47:14 PM

Page 1

Work Order ID: 64829

Parent Item: D3253-1

Parent Item Name: Small Shelf



Start Date: 12/16/10

Required Date: 12/20/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B 04.10.26 D3253-1 no longer made in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

sf

73.5000

1.296

2.592



B10-12-14

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT22

73.5

114351

73.5

114351

②

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DART AEROSPACE LTD		Work Order:	64829 44765
Description: Small Shelf (Dual Battery Rack)		Part Number:	D3253-1
Inspection Dwg: D3253	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.289	+/-0.010	23.289	X		T Bol	
1.425	+/-0.010	1.425	X		V	
R0.19	+/-0.030	.19	X		R.G	
0.697	+/-0.010	.697	X		V	
6.502	+/-0.010	6.504	X		V	
5.200	+/-0.010	5.201	X		V	
1.300 Pitch	+/-0.010	1.301	X		V	
Ø0.098	+0.005/-0.000	.100	X		V	
0.300	+/-0.010	.299	X		V	
R0.13	+/-0.030	.13	X		R.G	
0.651	+/-0.010	.650	X		V	
0.643	+/-0.010	.643	X		V	
8.000	+/-0.010	8.025	X		V	
7.508	+/-0.010	7.507	X		V	
R0.13	+/-0.030	.13	X		R.G.	
0.063	+/-0.005	.063	X		V	
Grain along 23.289	N/A		X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-12-16	Date: 10/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue P/O D205-579-015	KJ/JLM	[Signature]

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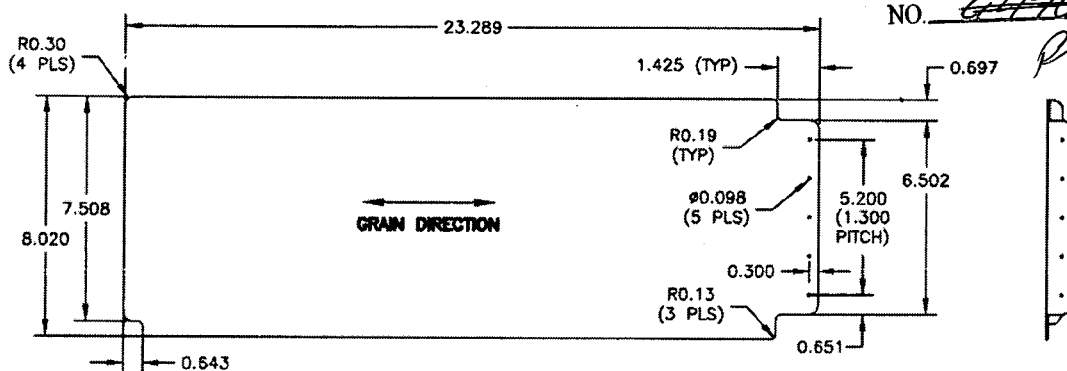


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3253	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SMALL SHELF (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

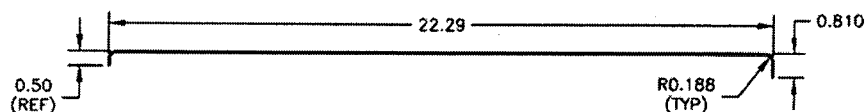
RELEASED
04.05.04

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. ~~64476~~ 564829
211012-16



FLAT PATTERN



D3253-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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